

# Work Order ID 91541

October-12-12 11:26:43 AM

**\*91541\***

Page 1

Item ID: D3589-23 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Arm Guide  
 Start Date: 10/09/12 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 10/19/12 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12-10-12 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3589	C

100 0.00  
**\*100\***  
 Hardinge Memo 0.00  
 Hardinge CNC Lathe Small 1-TURN AS PER FOLIO FA\*\*\*\* & DWG D3589  
 FOLIO REV: C Manual  
 DWG REV: C  
 2-DEBURR AS REQUIRED

110 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control QC2- Inspect parts off machine FAI/FAIB

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other	

# Work Order ID 91541

**\*91541\***

Page 2

October-12-12 11:26:43 AM

Item ID: D3589-23

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Arm Guide

Start Date: 10/09/12 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 10/19/12 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

B.O 12/10/12

5 0

130

Identify as per dwg & Stock Location: WA

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

5x

SP 12-10-17

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/10/12

12-10-18

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

# Picklist Print

October-12-12 11:26:43 AM

Page 1

Work Order ID: 91541

Parent Item: D3589-23

Parent Item Name: Arm Guide

Start Date: 10/09/12

Required Date: 10/19/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.07.23 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000 304 round bar 1.00		Purchased	No			100	f	23.7970	0.0542	0.2282105			

## Location

## Loc Qty

## Loc Code

MAT029

23.797

109508

0.085

113457

11.712

122504

12

M121282

.4 12-10-16

304 R.750  
Qd 12-10-16

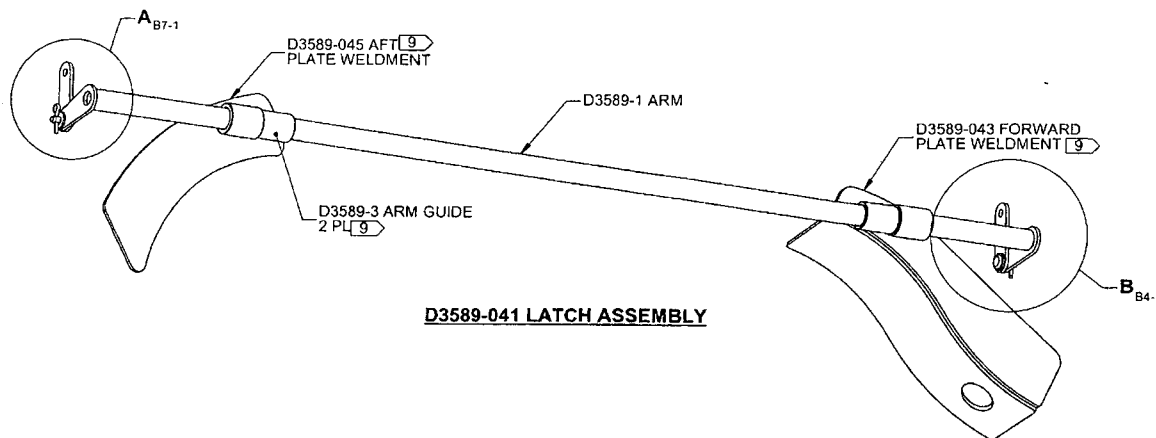
NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

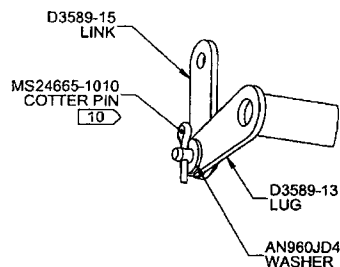
DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

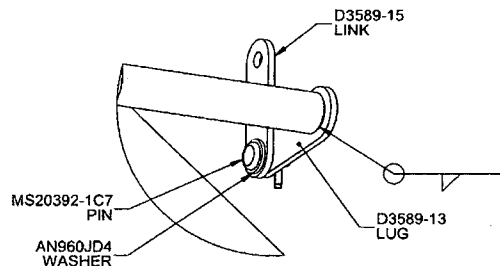
Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
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Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
<b>FAULT CATEGORY</b>											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other		



**D3589-041 LATCH ASSEMBLY**



**DETAIL A: LINK ASSEMBLY DETAIL** D8-1  
SCALE 2X  
2 PL



**DETAIL B: WELDING AND LINK ASSEMBLY DETAIL** C3-1  
SCALE 2X  
2 PL

**D3589-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK: SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.75 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

ITEM	QTY. -041	P/N	DESCRIPTION
	X	D3589-041	LATCH ASSEMBLY
1	1	D3589-043	FORWARD PLATE WELDMENT
2	1	D3589-045	AFT PLATE WELDMENT
3	1	D3589-1	ARM
4	2	D3589-3	ARM GUIDE
5	2	D3589-13	LUG
6	2	D3589-15	LINK
7	4	AN960JD4	WASHER
8	2	MS20392-1C7	PIN
9	2	MS24665-1010	COTTER PIN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 91541 MLJ  
12-10-12

**RELEASED**  
2012-07-16

C	REVISED D3589-5: 2.75 WAS 3.00 (ZN B6-4); ADDED D3589-21 (ZN B3-4); AFFECTS D3589-047 (ZN A7-3) AND D3589-049 (ZN A3-3); REVISED D3589-15: Ø0.140 WAS Ø0.129 (ZN B4-7); 0.900 WAS 1.150 (ZN C4-7); ADDED D3589-23 (ZN C3-1); AFFECTS D3589-043-045 (ZN D7-2 AND D2-2); REASON: PART 12-177.	MB	12.07.04
B	0.80 AND 0.63 REF WERE 1.87 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29" WAS 15" (ZN B2-2); 18.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.07.04		

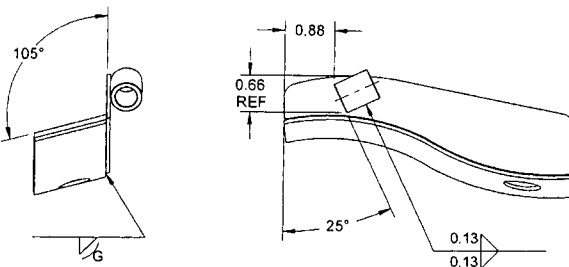
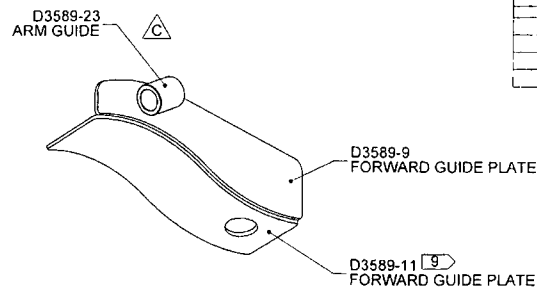
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3589** REV. C  
SHEET 1 OF 8  
TITLE **LATCH ASSEMBLY** SCALE NTS

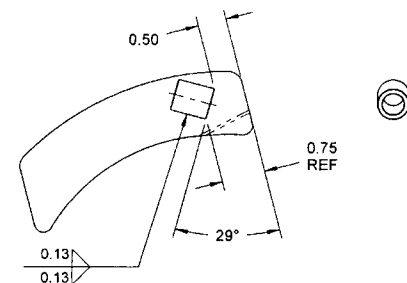
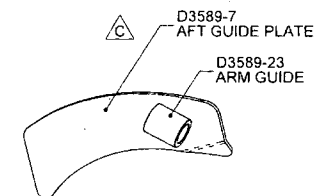
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91541

ITEM	QTY -043	QTY -045	P/N	DESCRIPTION
	X		D3589-043	FORWARD PLATE WELDMENT
		X	D3589-045	AFT PLATE WELDMENT
1		1	D3589-7	AFT GUIDE PLATE
2	1		D3589-9	FORWARD GUIDE PLATE
3	1		D3589-11	FORWARD GUIDE PLATE
4	1	1	D3589-23	ARM GUIDE



**D3589-043 FORWARD PLATE WELDMENT**



**D3589-045 AFT PLATE WELDMENT**

**RELEASED**  
2012-07-16

**D3589-043/-045 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
  - D3589-043 = 0.23 lbs
  - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3589 SHEET 2 OF 8
APPROVED		TITLE SCALE
DE APPR.		LATCH ASSEMBLY NTS
DATE	12.07.04	

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91541

ITEM	QTY -047	QTY -049	P/N	DESCRIPTION
	X		D3589-047	FORWARD GUIDE
		X	D3589-049	AFT GUIDE
1	1		D3589-5	LATCH GUIDE
2	1		D3589-17	FORWARD GUIDE PLATE
3		1	D3589-19	AFT GUIDE PLATE
4		1	D3589-21	LATCH GUIDE

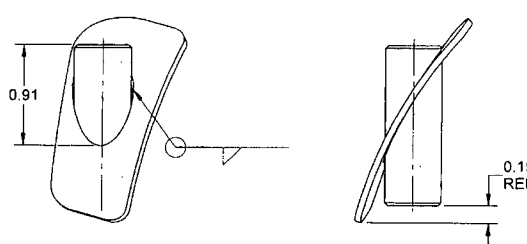
D3589-17  
FORWARD GUIDE PLATE

D3589-5  
LATCH GUIDE

D3589-21  
LATCH GUIDE

D3589-19  
AFT GUIDE PLATE

 **D3589-047 FORWARD GUIDE**

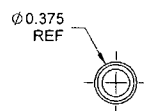
 **D3589-049 AFT GUIDE**

**D3589-047/-049 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
  - D3589-047 = 0.08 lbs
  - D3589-049 = 0.05 lbs
- 8) WELDING: PER DART QSI 004

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3589</b>	REV. C
MFG. APPR.		SHEET 3 OF 8	
APPROVED		TITLE <b>LATCH ASSEMBLY</b>	SCALE
DE APPR.		NTS	
DATE	12.07.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

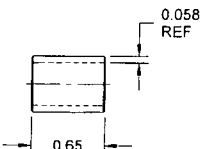
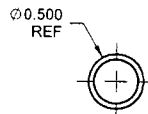
91541



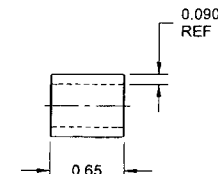
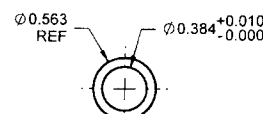
0.03 X 45°  
CHAMFER  
2 PL



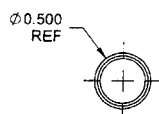
**D3589-1 ARM**



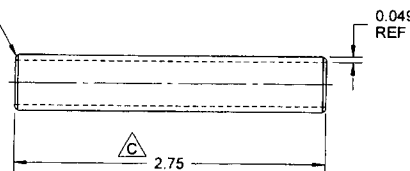
**D3589-3 ARM GUIDE**



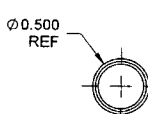
**D3589-23 ARM GUIDE**



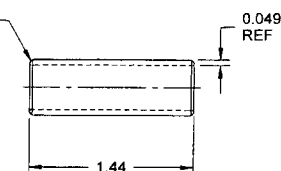
0.03 X 45°  
CHAMFER  
2 PL



**D3589-5 LATCH GUIDE**



0.03 X 45°  
CHAMFER  
2 PL



**D3589-21 LATCH GUIDE**

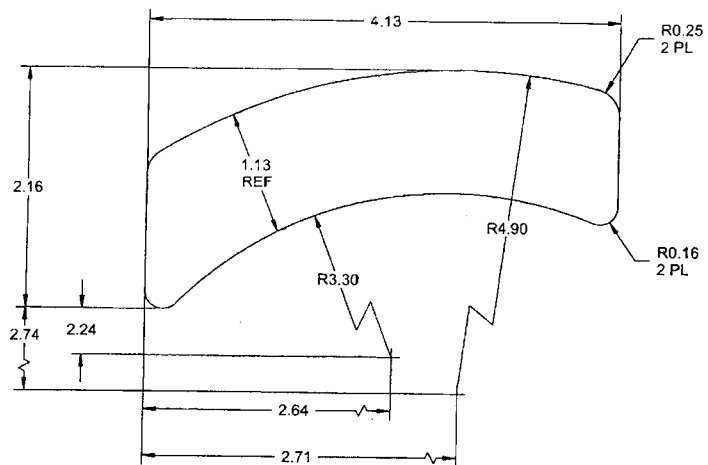
**D3589-1/-3/-5/-21/-23 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING  
 D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)  
 D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)  
 D3589-5/-21: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)  
 D3589-23: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276 (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs  
 - D3589-3 = 0.01 lbs  
 - D3589-5 = 0.06 lbs  
 - D3589-21 = 0.03 lbs  
 - D3589-23 = 0.02 lbs

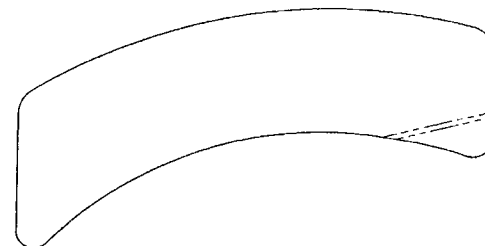
RELEASED  
2012-07-16

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3589</b>	REV. C
MFG. APPR.		TITLE <b>LATCH ASSEMBLY</b>	SHEET 4 OF 8
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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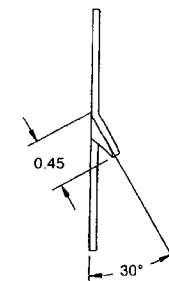
91541



**D3589-7F AFT GUIDE PLATE  
FLAT PATTERN**



**D3589-7 AFT GUIDE PLATE**  
MAKE FROM D3589-7F



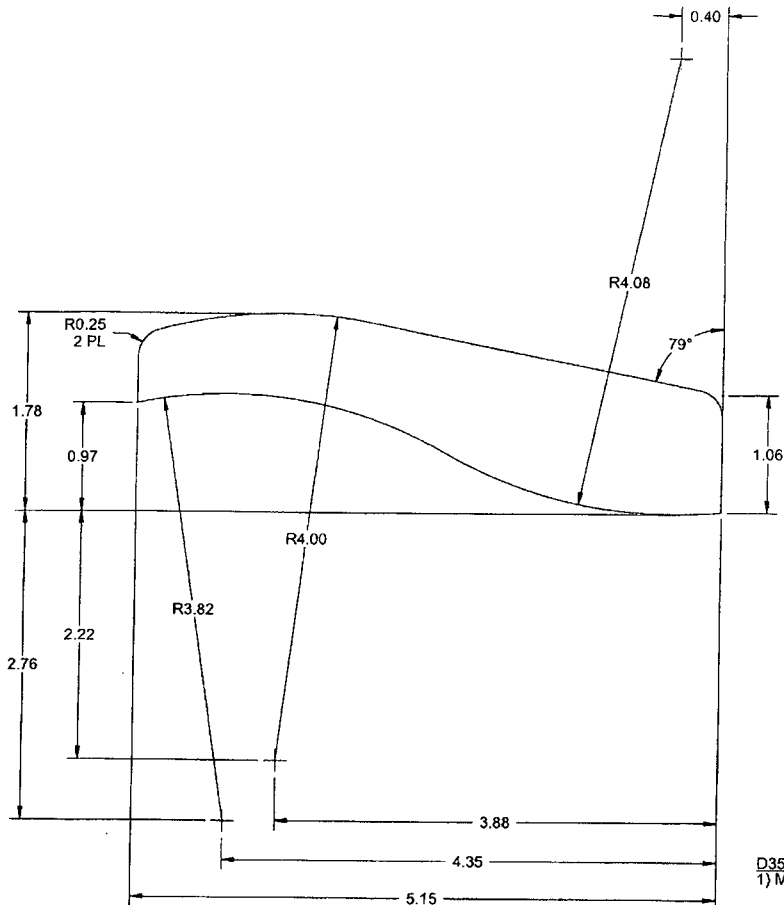
**RELEASED**  
2012-07-16  
AW

**D3589-7F NOTES:**

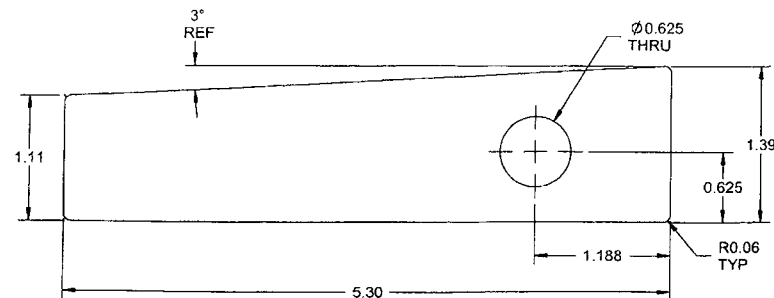
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3589</b>	REV. C
MFG. APPR.			SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>LATCH ASSEMBLY</b>	NTS
DATE	<b>12.07.04</b>	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

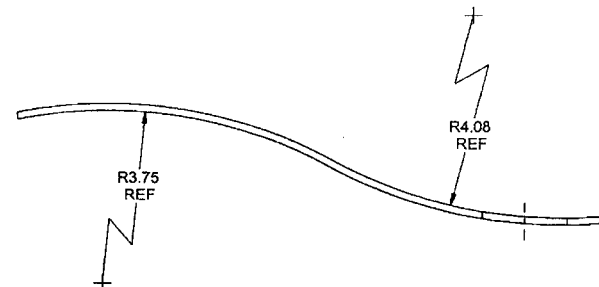
91541



**D3589-9 FORWARD GUIDE PLATE**



**D3589-11F FORWARD GUIDE PLATE  
FLAT PATTERN**



**D3589-11 FORWARD GUIDE PLATE  
(MAKE FROM D3589-11F)**

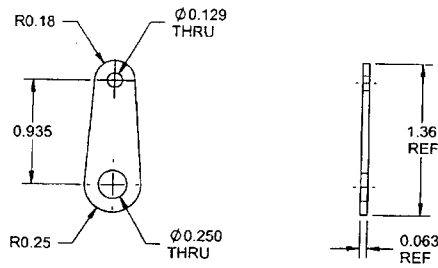
- D3589-9/-11/-11F NOTES:**  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET,  
 PER AMS 5513 OR AMS 5524,  
 OR MIL-S-5059 (ANNEALED) 2B FINISH  
 16 GAUGE (0.063 THICK).  
 (REF. DART SPEC M304S16GA)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS  
 OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.09 lbs EACH  
 8) CONTROL SHAPE PER DT9021 TEMPLATE

**RELEASED**  
 2012-07-16

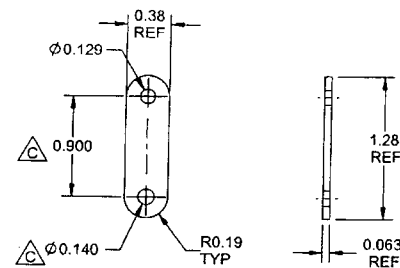
DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D3589</b>
MFG. APPR.		REV. C
APPROVED		SHEET 6 OF 8
DE APPR.		TITLE <b>LATCH ASSEMBLY</b>
DATE	12.07.04	SCALE <b>NTS</b>

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**D3589-13 LUG**



**D3589-15 LINK**

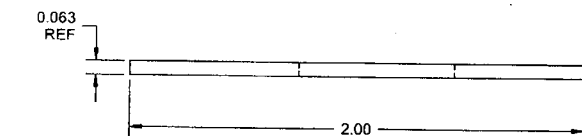
RELEASED  
2012-07-16  
MD

**D3589-13/-15 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3589</b>	REV. C
MFG. APPR.			SHEET 7 OF 8
APPROVED		TITLE <b>LATCH ASSEMBLY</b>	SCALE
DE APPR.			NTS
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A horizontal number line with tick marks labeled 1 through 8 from right to left. The line is slightly curved and has a dashed vertical line near the right end.



Technical drawing of a mechanical part. The main view shows a profile with the following dimensions and features:

- Overall width: 1.250
- Top-left radius: R0.25
- Top-right radius: R0.50
- Left vertical height: 0.63
- Bottom-left radius: R0.505
- Bottom-right radius: R0.13
- Bottom-right label: 2 PL
- Internal vertical distance: 0.500
- Internal angle: 20°
- Internal vertical distance: 0.95
- Bottom horizontal distance: 1.025

A side view at the bottom shows the part's length as 2.050 and its thickness as 0.063 REF.

RELEASE  
2012-07-16

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,  
OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)

2) FINISH: NONE


3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.02 lbs EACH

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3589	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>LATCH ASSEMBLY</b>	NTS
DATE	12.07.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRINTED TO SCALE AND THE SPECIFIC CONDITION PART IS NOT TO BE USED FOR ANY PURPOSE OR ON ANY COMPONENT TO ANY OTHER PERSON WITHOUT PERMISSION OF DART AEROSPACE LTD.</small>	



10

10/10/10

10/10/10

10

10/10/10